

Work Order ID 61431

Wednesday, August 25, 2010 9:12:07 AM

Page 1

Item ID: D3836-042

Accept

Setup Start

Revision ID:

Stop

Item Name: Rib Assembly (Basket Lid, RH)

Start Date: 8/25/2010 Start Qty: 2.00

Cust Item ID:

Required Date: 9/1/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-8-25

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3836

Rev A

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- cut D3836-2 and D3836-3 rib as per dwg D3836

2- remove identification markings

3- deburr

4- weld D3836-2 to D3836-3 and drill hole (3/16") using DT9447 jig and open to finish size as per dwg D3836

5- weld D2327-3 spacer bushing as per dwg D3836

A/R ER316 S.S. Rod Batch: 1114649

6- grind weld flush where indicated on dwg

LS 10/09/21 (42)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D3836-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly (Basket Lid, RH)

Start Date: 8/25/2010 Start Qty: 2.00



Cust Item ID:

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Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

(4) 10/09/21

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S. 10/09/21

(x4) 10/09/21

150



Packaging

Packaging

Identify as per dwg & Stock Location: _____

0.00

Basket call

Memo

0.00

10/09/21 (4x)

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Work Order ID 61431


Wednesday, August 25, 2010 9:12:07 AM

Page 3

Item ID: D3836-042 Accept  Setup Start 
Revision ID: Stop 
Item Name: Rib Assembly (Basket Lid, RH)
Start Date: 8/25/2010 Start Qty: 2.00  Cust Item ID:
Required Date: 9/1/2010 Req'd Qty: 2.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

10/09/22 
mf
10-9-21

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Wednesday, August 25, 2010 9:12:11 AM

Page 1

Work Order ID: 61431

Parent Item: D3836-042

Parent Item Name: Rib Assembly (Basket Lid, RH)

Start Date: 8/25/2010


Required Date: 9/1/2010

Start Qty: 2.00

Required Qty: 2.00


Comments: IPP Rev:A 08-12-01 new issue DD verified by:cC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2327-3  Spacer Bushing		Manufactured	No			100	Each	31.0000	1	2			
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Location	Loc Qty	Loc Code
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WA	31	
58406	1	
58974	1	
60320	9	
60952	20	

M304TS0.750W.065  304 SQ Tube .75x.75x.065W		Purchased	No			100	f	44.7532	1.7808	3.749063			
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Location	Loc Qty	Loc Code
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MAT	1.4628	
112398	0	
114482	1.4628	
WA	43.290385	
114520	11.363385	
115274	31.927	

M 115274 - 3.75 + 1 (END BAR SCRAP)

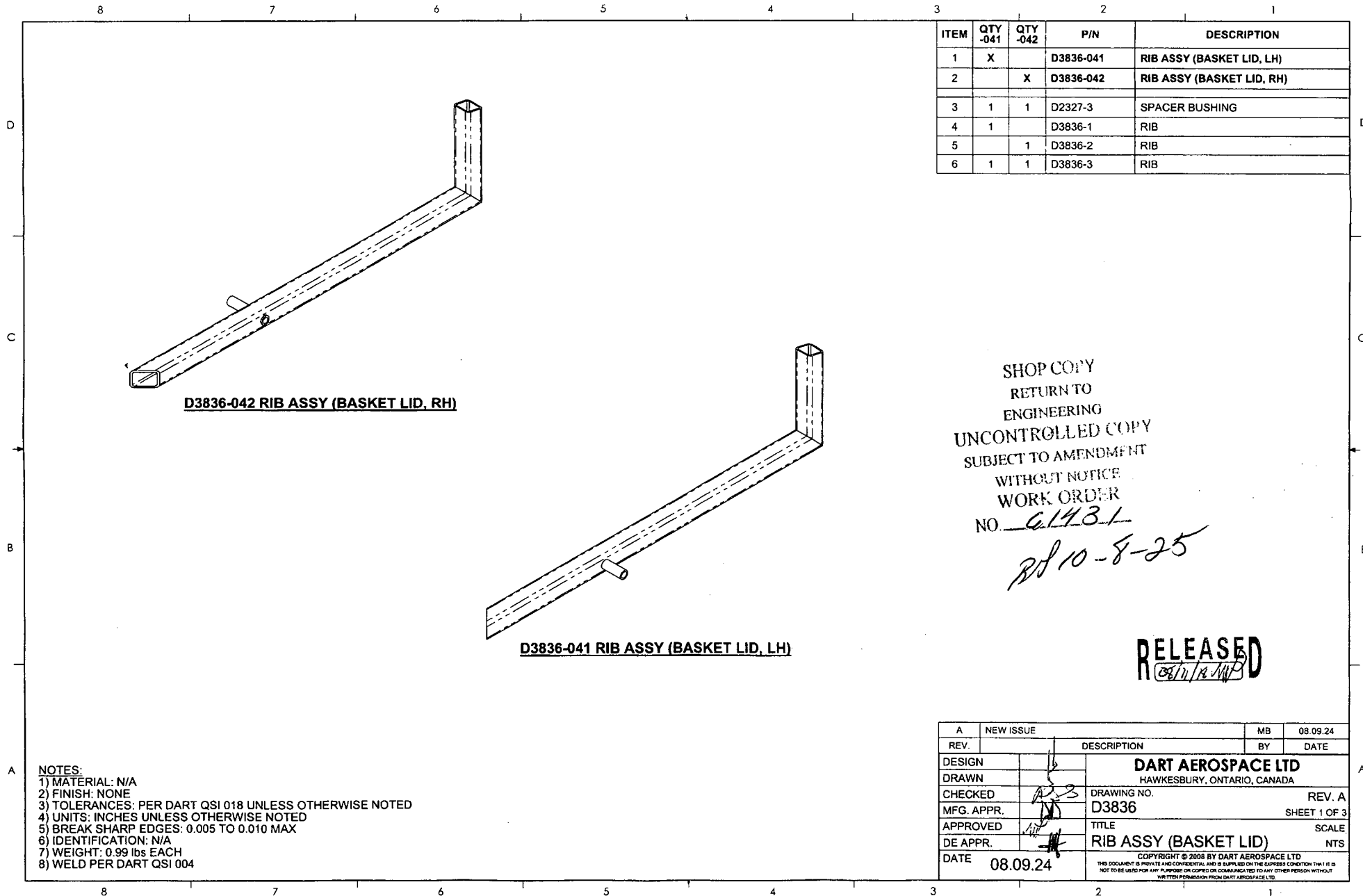
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NOTE: Date & initial all entries

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C

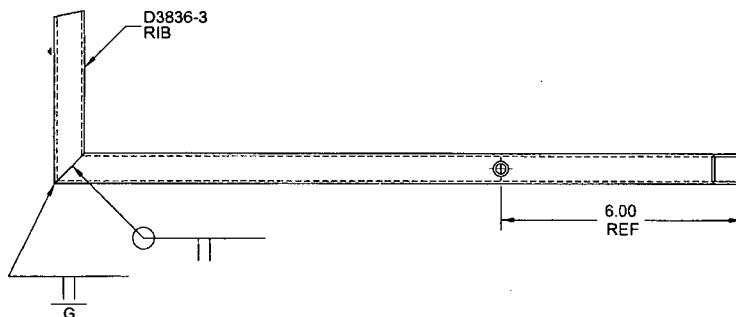
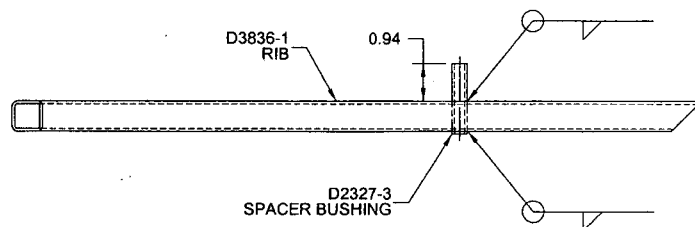
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B

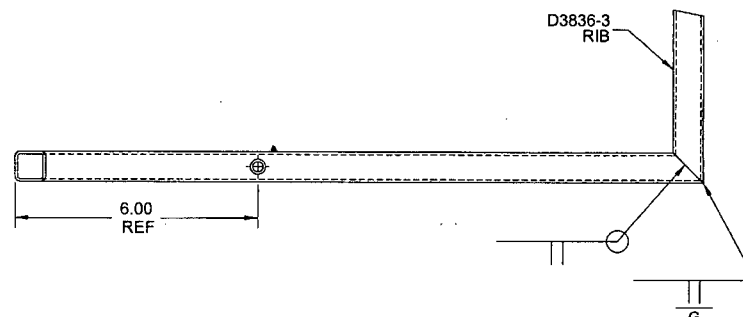
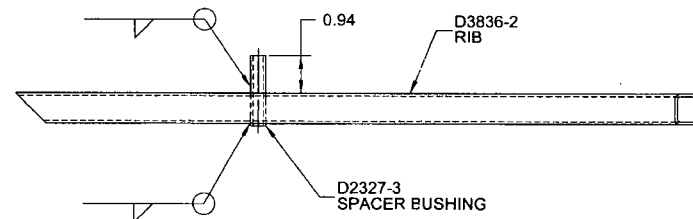
B

A

A



D3836-041 RIB ASSY (BASKET LID, LH)



D3836-042 RIB ASSY (BASKET LID, RH)

cel 6 61431

RELEASED
08/11/18

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3836	REV. A
MFG. APPR.			SHEET 2 OF 3
APPROVED		TITLE RIB ASSY (BASKET LID)	SCALE
DE APPR.			NTS
DATE	08.09.24	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

8

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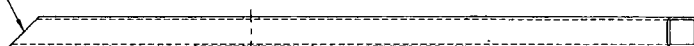
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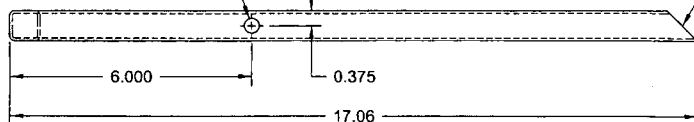
NOTE: Date & initial all entries

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CHAMFER

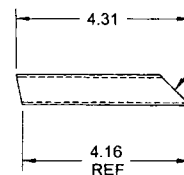


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0.75 X 45°
CHAMFER

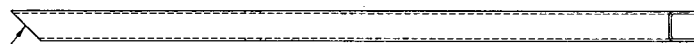


D3836-1 RIB



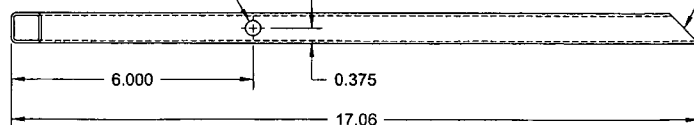
D3836-3 RIB

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CHAMFER

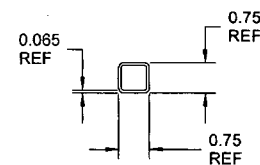


$\varnothing 0.375^{+0.020}_{-0.000}$ THRU

0.75 X 45°
CHAMFER



D3836-2 RIB



**TYPICAL SECTION
VIEW**

RELEASED
08/11/84

w/o 61431

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3836-1/2 = 0.78 lbs EACH; D3836-3 = 0.19 lbs

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
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